

Work Order ID 73454



Page 1

Thursday, September 01, 2011 7:32:33 AM

Item ID: D3290-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Window					
Start Date: 8/31/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 9/16/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/09/01</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3290	Rev C

100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290		<input type="checkbox"/> Dwg Rev: <u>C</u>	<input type="checkbox"/> Prog Rev: <u>C</u>	<input type="checkbox"/> 2-				
<u>1/8</u> PLEYI	Deburr if necessary								

HB 11-9-08

(8)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									

HB 11-9-08

120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
Quality Control									

8/10/08/27

(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Without removing protective skin <input type="checkbox"/> remove sharp edge by degurring.	0.00 0.00				<u>8</u>			<u>Sh</u> 11/09/30
140 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-THERMOFORM as per Drawing D3290 and Folio FTA001 <input type="checkbox"/> Dwg. Rev. <u>C</u> <input type="checkbox"/> Folio Rev <u>B</u> <input type="checkbox"/> 2-Engrave part# & batch#, <input type="checkbox"/> (D3290-3)	0.00 0.00				<u>8</u>			<u>Sh</u> 11/09/30
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>8</u>			<u>Sh</u> 11/09/30

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, September 01, 2011 7:32:33 AM

[illegible][illegible]

Stop

[illegible][illegible]**Cust Item ID:**

Customer:

Reference:

Run Start

The following table shows the results of the regression analysis for the dependent variable "Number of publications" (N = 100). The independent variables are "Gender" (Male/Female) and "Age" (20-30/31-40/41-50/51+). The table includes the coefficient, standard error, t-statistic, and p-value for each variable.

Variable	Coefficient	Standard Error	t-statistic	p-value
Gender (Male)	0.15	0.08	1.88	0.06
Gender (Female)	-0.12	0.07	-1.71	0.09
Age (20-30)	0.25	0.05	5.00	0.00
Age (31-40)	0.18	0.04	4.50	0.00
Age (41-50)	0.10	0.03	3.00	0.00
Age (51+)	0.05	0.02	2.50	0.01

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

Thermoforming Machine

Water sand and buff to remove scratches if required

180

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

Memo

0.00

QC

Quality Control

190

Identify as per dwg & Stock Location: B 73721 0.00

0.00

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73454

Thursday, September 01, 2011 7:32:33 AM



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Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/30
MF
11-09-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:32:30 AM

Page 1

Work Order ID: 73454



Parent Item: D3290-3



Parent Item Name: Window

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A 04.08.18 New issue KJ/RF
 IPP B 06.05.09 Ecn 798 EC IPP Rev.
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29 Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased	No			100	sf	233.0934	3	18.94737	32		
1/8" Polycast II Sheet											811-9-28		

Location

Loc Qty

Loc Code

MAT 133.8467
 117431 133.8467
 MAT018 96.2467
 117324 43.7667
 117340 52.48
 MAT019 3
 115338 3

(8)

 117340

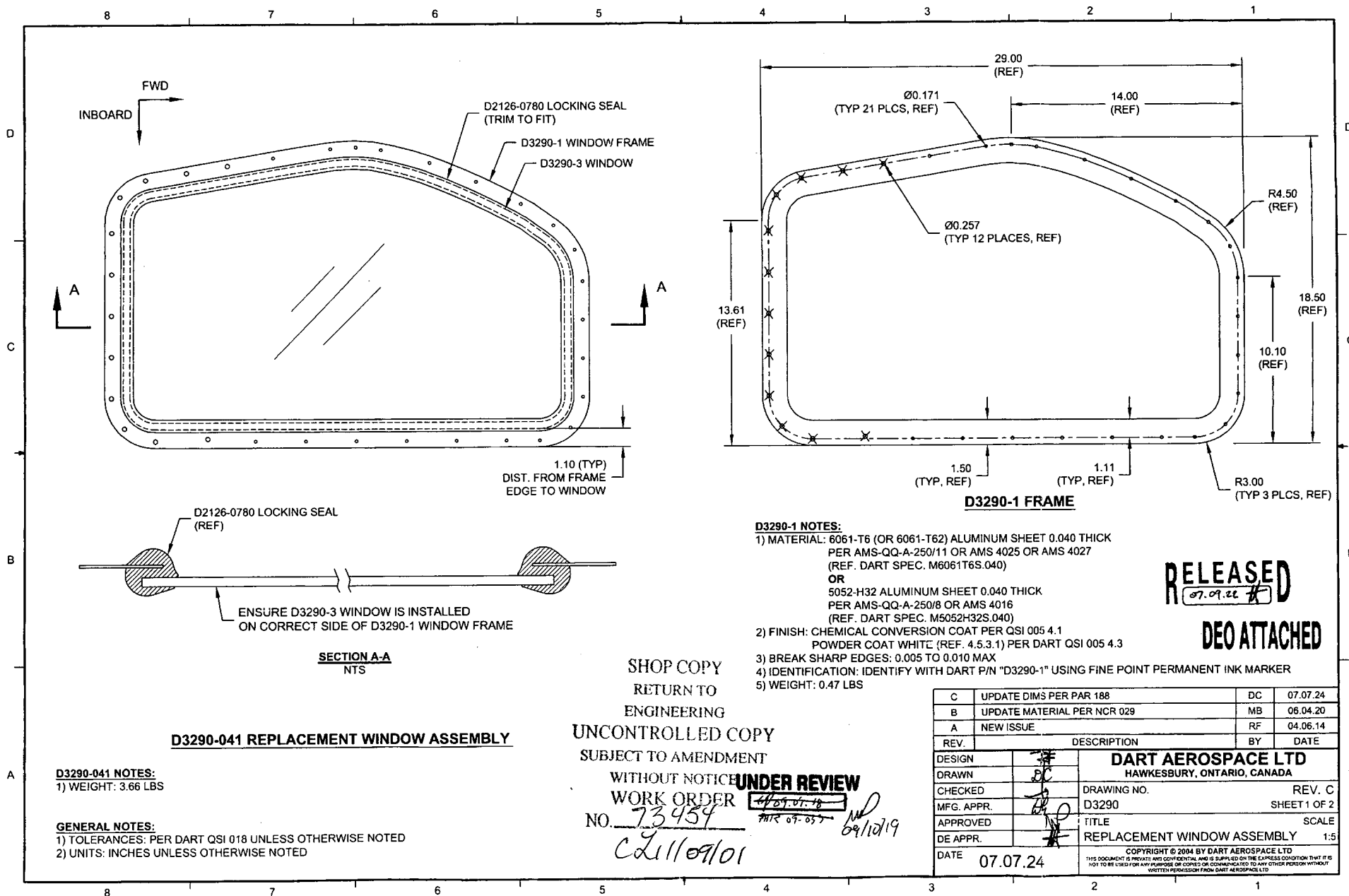
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

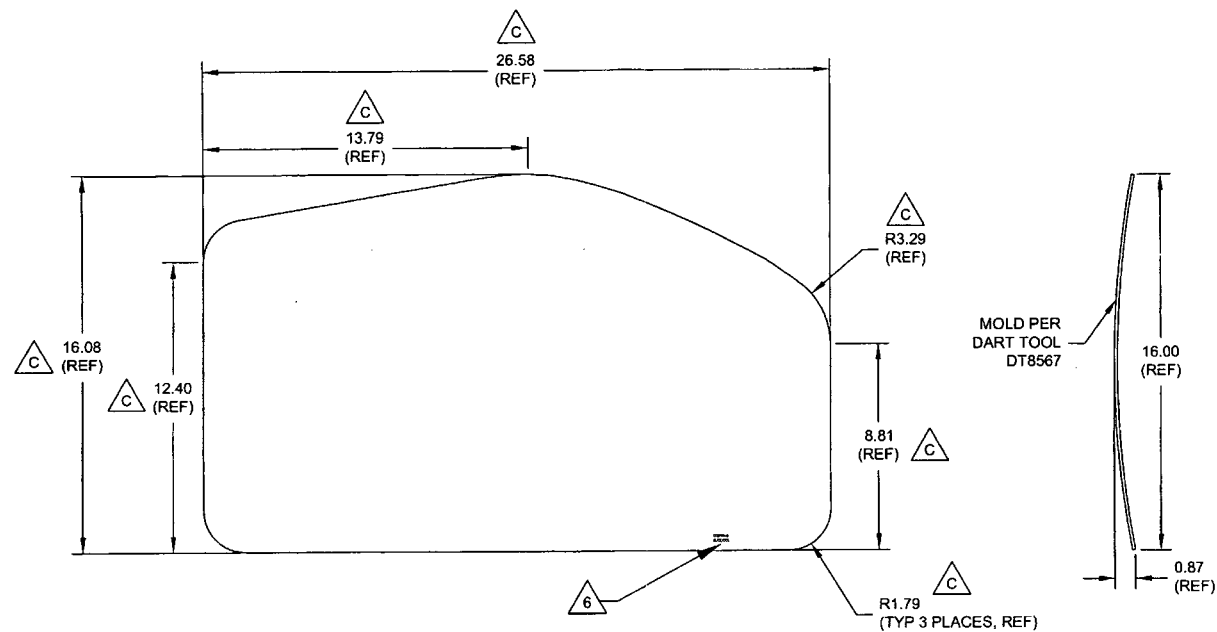
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3290-3 WINDOW



D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

MP/10/19
UNDER REVIEW
09.09.18
DEO ATTACHED
RELEASED
07.09.22

DESIGN	<i>32</i>	DART AEROSPACE LTD	
DRAWN	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JK</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JK</i>	D3290	SHEET 2 OF 2
APPROVED	<i>JK</i>	TITLE	SCALE
DE APPR.	<i>JK</i>	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>b</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>#</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
MP

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